

Date: Wednesday, 6/6/2007 3:45:44 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 32837	
Estimate Number : 10278	
P.O. Number : <i>N/A</i>	Part Number : D3121141
This Issue : 6/6/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3121 REV D
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 31727	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/30/2007 Qty: <i>12</i> Um: Each
Checked & Approved By : <i>[Signature] 07.06.07</i>	
Comment : Est Rev: Pick: A 04.02.18 New issue KJ/DS	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M174B1000X02000	17-4 SS Bar
-----	-----------------	-------------



Comment: Qty.: 0.5775 f(s)/Unit Total : 4.6200 f(s)
Material: 17-4 SS Bar per AMS 5604/5643
(M17-4-B1.000x02.000)
Identify for D3121-111
Batch: *M103089 x10 pcs M101422 x2 pcs*

J.L 07/09/11

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks: (1.000" x 2.000") 6.600" long

J.L 07/09/11

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-111 as per Folio FA361 and Dwg.D3121 Identify as D3121-111

2-Deburr

3-Scribe batch number

J.F. / J.L 07/09/11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. J.L 07/09/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 07/09/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 3:45:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 32837

Part Number: D3121141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SG 07.09.11

(12)

6.0

D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3121-21 * Bolt *B 33735 x4*

J.F. / J.L 07/09/11

7.0

D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3121-241 Bearing Ass. * *B 34473 x4*

J.F. / J.L 07/09/11

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-141 as per Dwg D3121.

J.L 07/09/11

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SG 07.09.11

(12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/9/11 SQ (12x)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ED 07/09/12

(12)

Job Completion



U 07/09/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 32837
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	.393	✓			
0.75	+/-0.030	.750	✓			
0.375	+/-0.010	.375	✓			
2.14	+/-0.030	2.149	✓			
0.950	+/-0.010	.950	✓			
0.600	+/-0.010	.600	✓			
1.96	+/-0.030	1.965	✓			
0.280	+/-0.010	.285	✓			
3.330	+/-0.010	3.330	✓			
3.630	+/-0.010	3.635	✓			
R0.25	+/-0.030	r.250	✓			
R0.375	+/-0.010	r.375	✓			
Ø0.201	+0.005/-0.000	.201	✓			
0.100	+/-0.010	.100	✓			
6.18	+/-0.030	6.180	✓			
5.89	+/-0.030	5.900	✓			
0.080	+/-0.010	.080	✓			
0.300	+/-0.010	.301	✓			
30°	+/-0.1°	30°	✓			
R0.25	+/-0.030	r.250	✓			
0.130	+/-0.010	.131	✓			
0.381	+/-0.010	.385	✓			
0.281 0.201	+/-0.010	.204	✓			EC
0.400	+/-0.010	.397	✓			
0.580	+/-0.010	.585	✓			
100°	+/-0.1°	100°	✓			
0.32 0.032	+/-0.010	.029	✓			EC

Measured by: J.L.	Audited by: gmk	Prototype Approval: N/A
Date: 07/09/06	Date: 07/09/06	Date: N/A

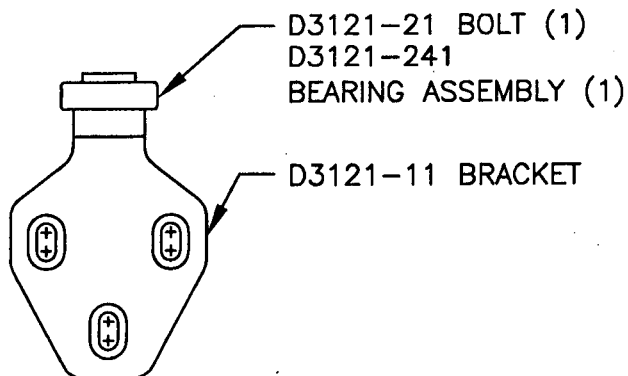
Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	JA



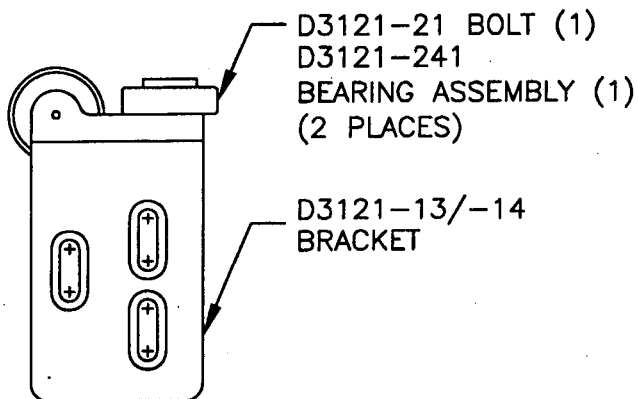
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		D3121	SHEET 1 OF 10
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	

RELEASED

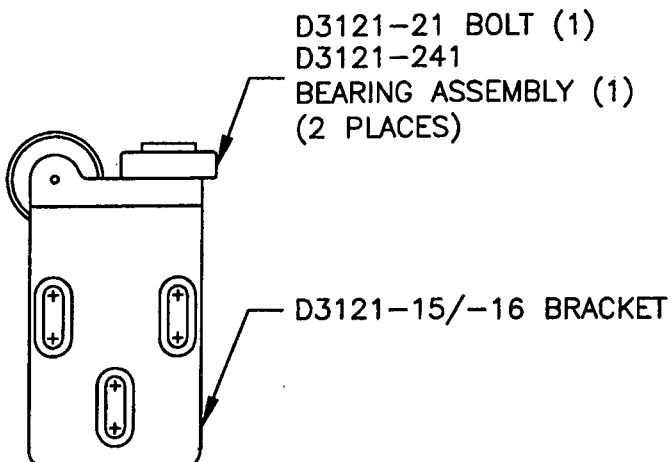
06.06.02



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

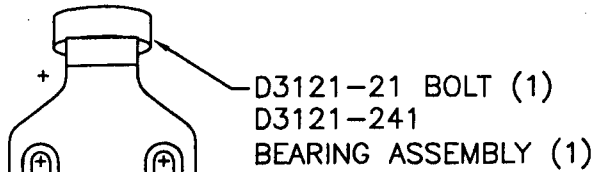
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DATE 06.05.17		TITLE BRACKET ASSEMBLY	SCALE 1:2

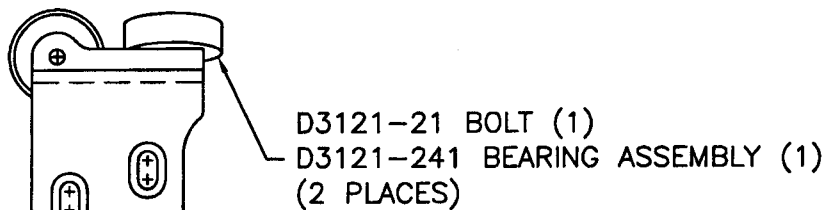


D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

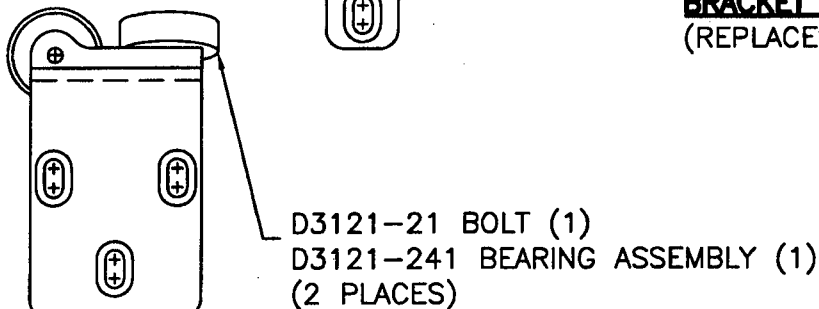
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06.06.02 J.H.



D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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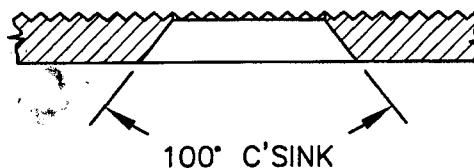
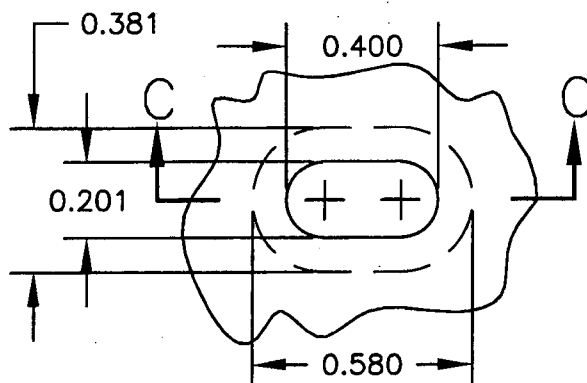
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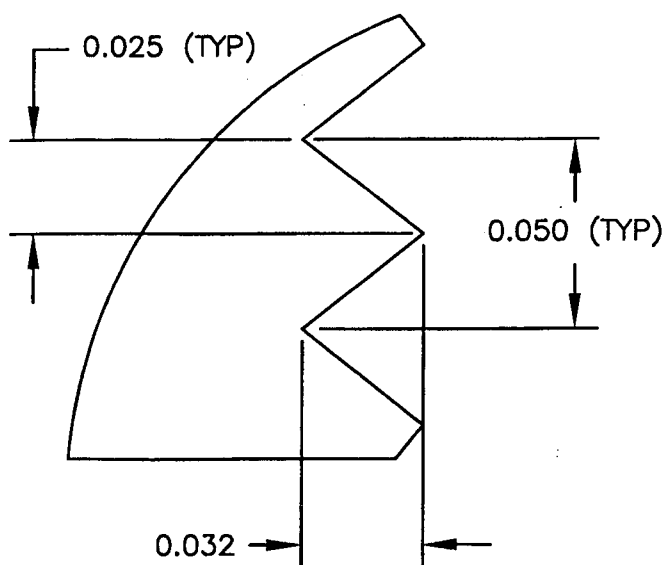
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DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



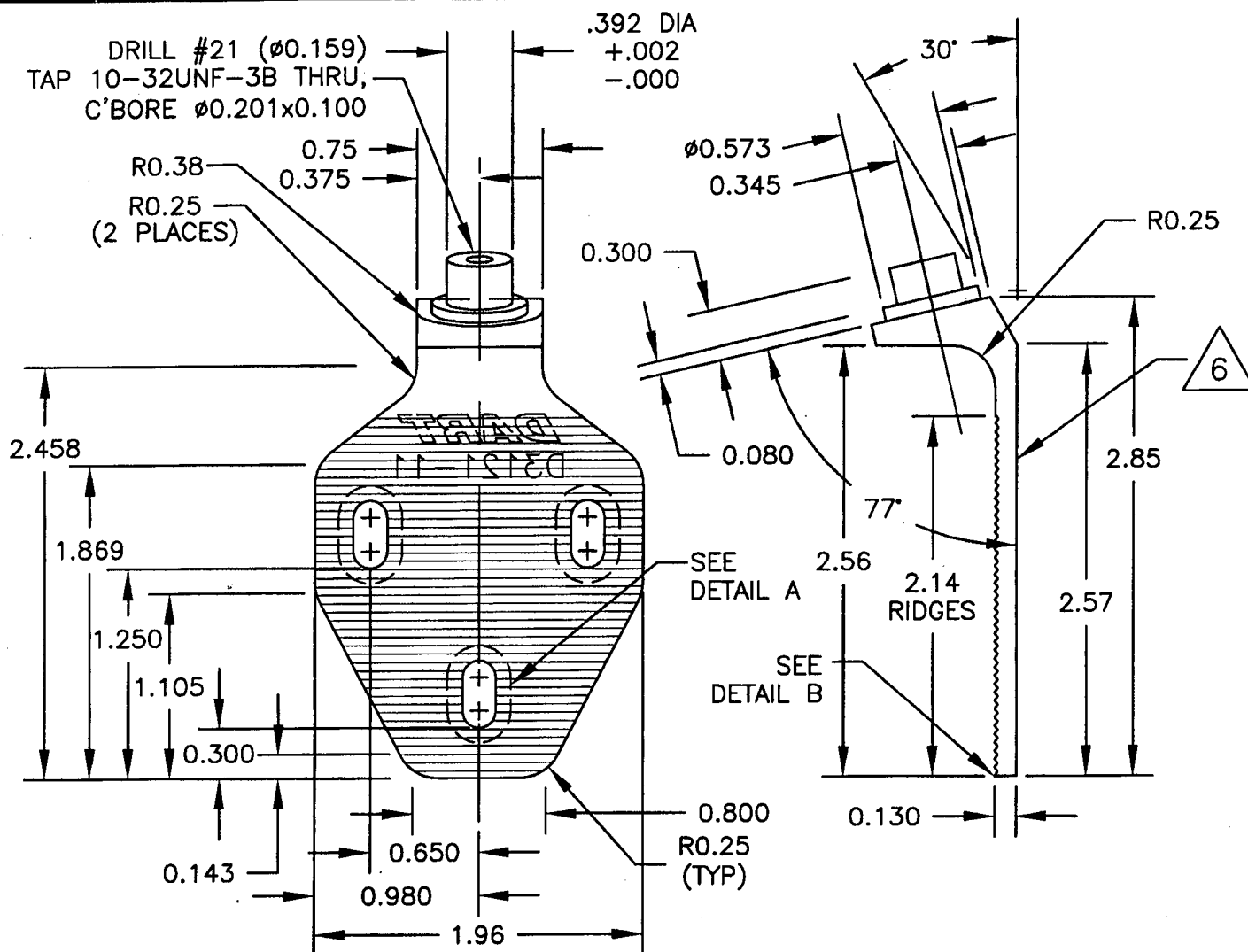
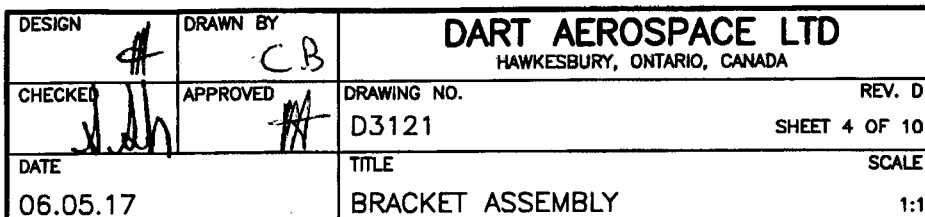
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1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

5) ENGRAVE DART P/N & LOGO AS SHOWN

6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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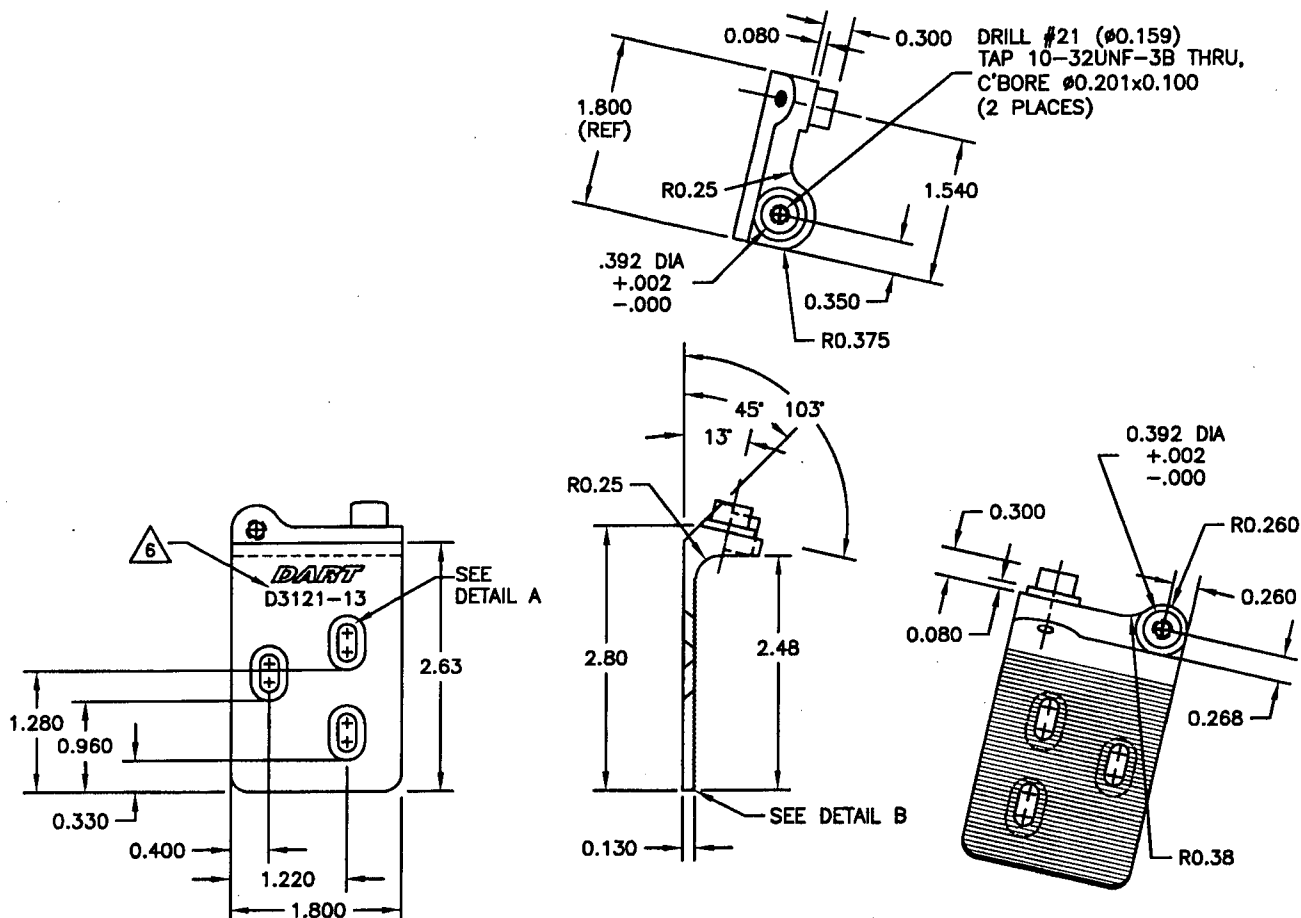
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DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:2



D3121-13 BRACKET (SHOWN)

D3121-14 BRACKET (OPPOSITE)

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE STRENGTH = 150 ksi

MIN YIELD TENSILE STRENGTH = 100 ksi

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

5) ENGRAVE DART P/N & LOGO AS SHOWN

6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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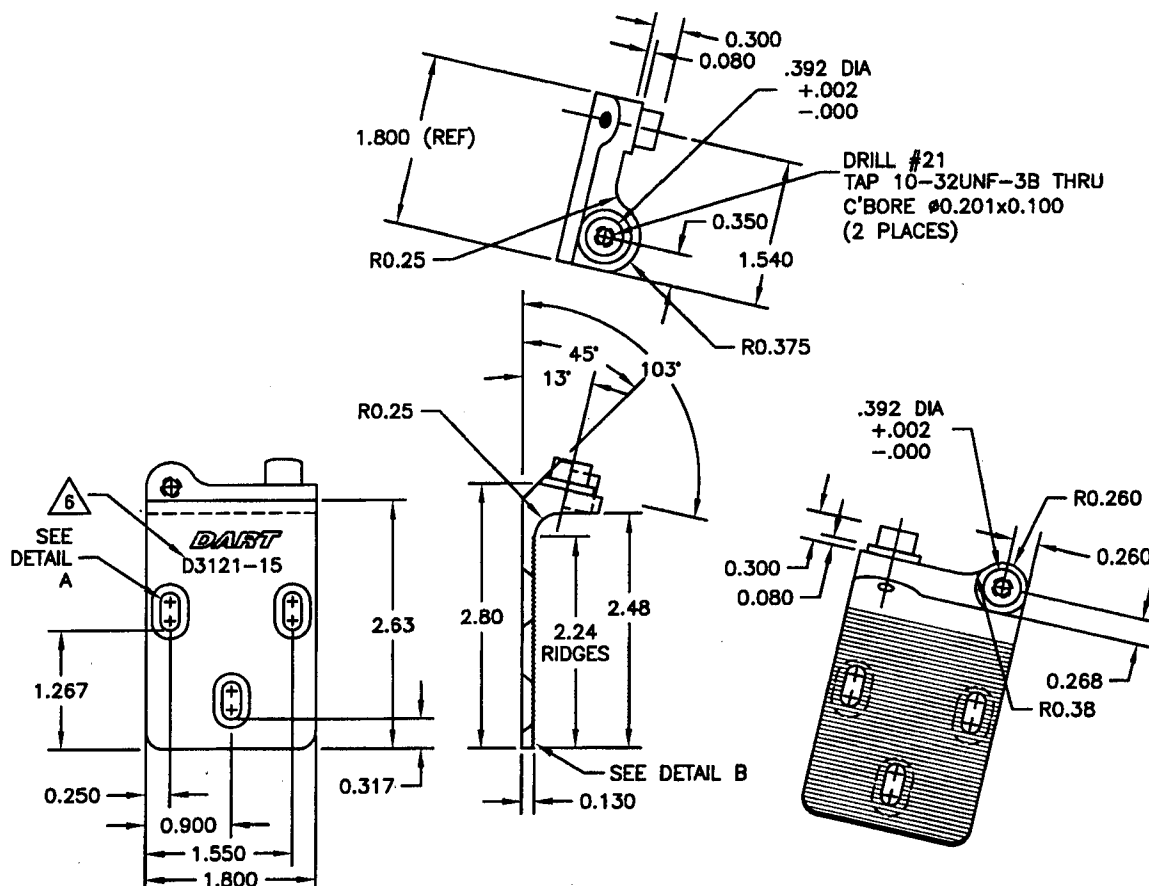
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DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:2



D3121-15 BRACKET (SHOWN)

D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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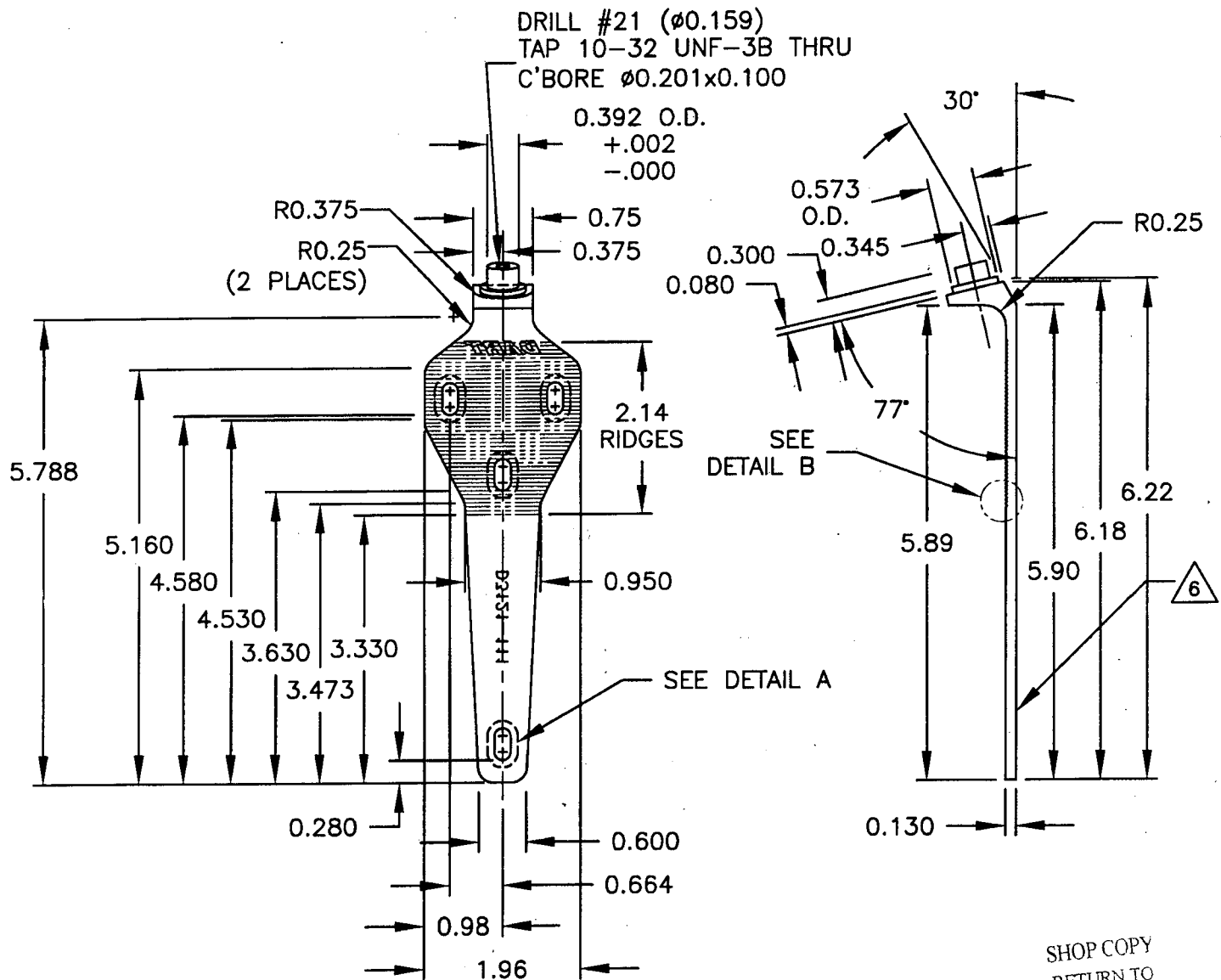
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DART

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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. D SHEET 7 OF 10
DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:2

**D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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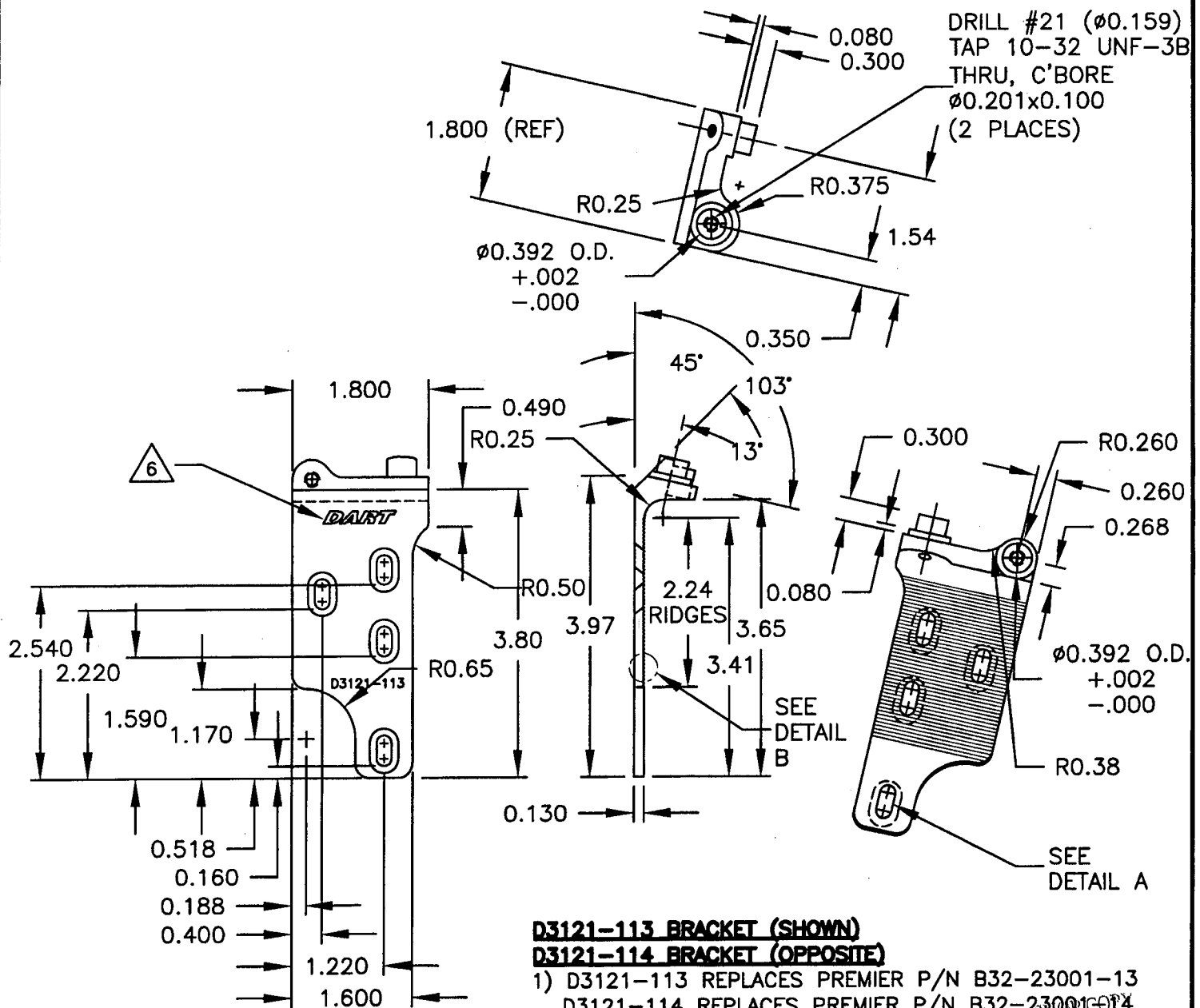
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. D SHEET 8 OF 10
DATE 06.05.17		TITLE BRACKET ASSEMBLY	SCALE 1:2

**D3121-113 BRACKET (SHOWN)****D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14

- 2) MATERIAL: 17-4 SS PER AMS 5604/5643

(REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE STRENGTH = 150 ksi

MIN YIELD TENSILE STRENGTH = 100 ksi

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES

- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN

- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

RELEASE

06.06.02 #

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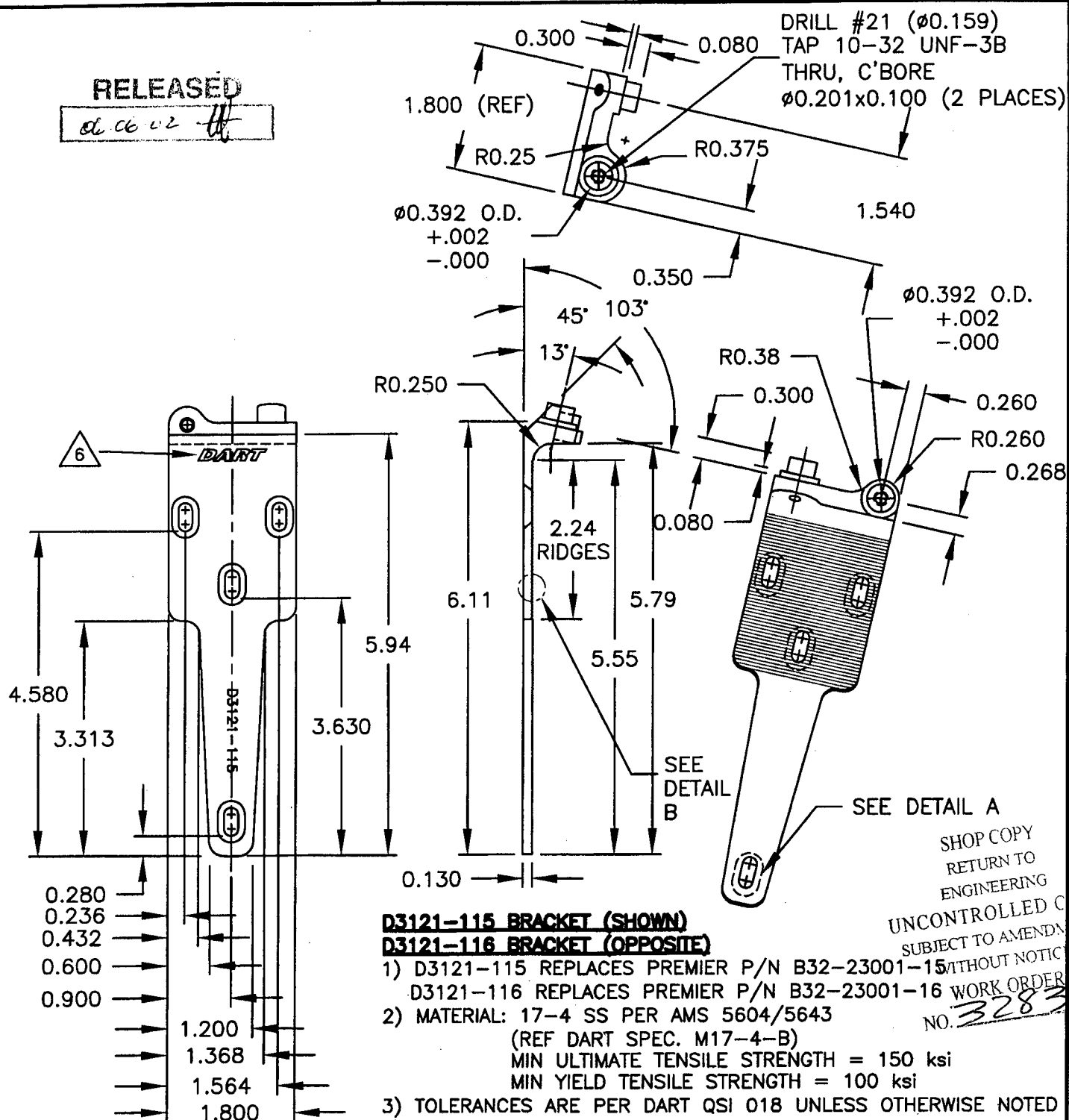
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CHECKED J.H.	APPROVED J.H.	DRAWING NO. D3121	REV. C SHEET 9 OF 10
DATE 04.02.18	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED

04.06.02

**D3121-115 BRACKET (SHOWN)****D3121-116 BRACKET (OPPOSITE)**

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

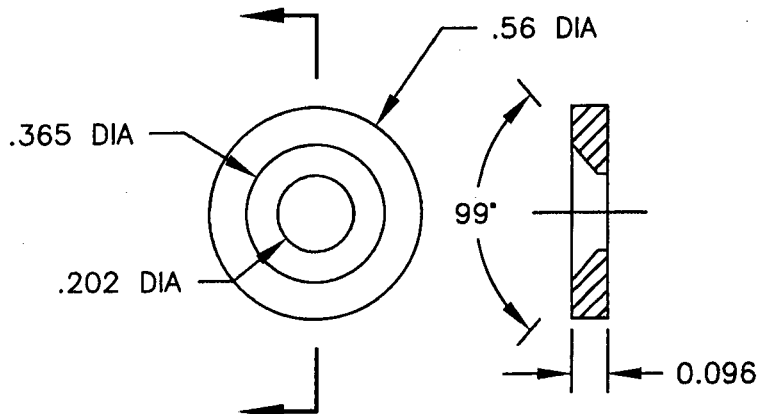
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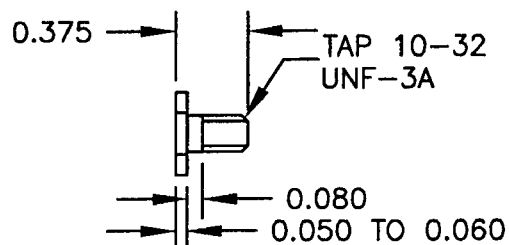
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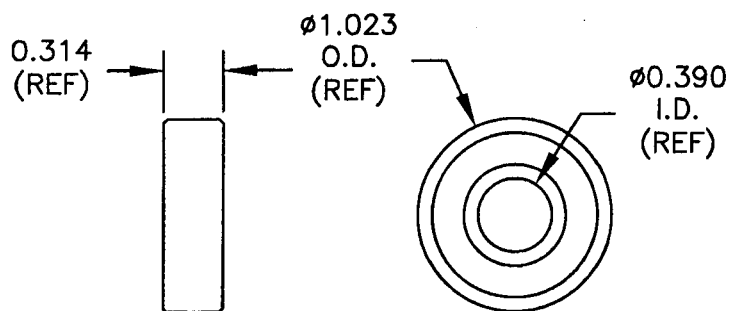
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CHECKED J.H.	APPROVED J.H.	DRAWING NO. D3121	REV. D SHEET 10 OF 10
DATE 06.05.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

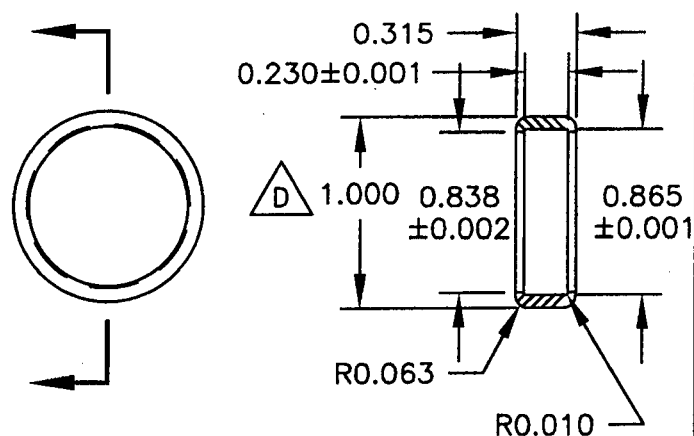
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-21 BOLT (SCALE 1:1)**

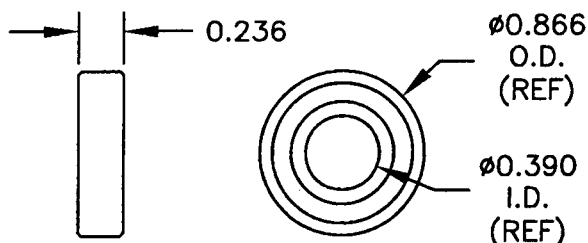
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

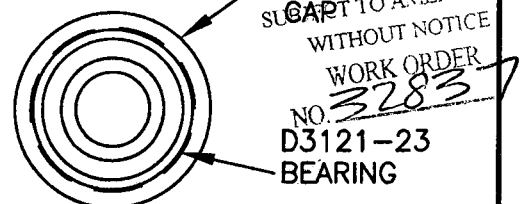
**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

RELEASED
06-06-02

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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